



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5763-11

Job Sheet 207395

M22
SPB 25/20

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Part No: D5763-11

Job Qty: 10 pcs

Part Name: Block

20 pcs

Status: New

Priority: Medium



Part Weight: 0 lbs

Job Created: 2/25/20

Job Tracking No:

Due Date: 3/6/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 2020-525 Was PN: 69830-07 DWG D5763 REV.A IPP REV:A 19.12.19 NEW ISSUE JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	10 pcs	3/6/20	3/6/20	0.00	0.20	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		<i>MAL</i>
110	QC 5	10 pcs	3/6/20	3/6/20	0.00	0.00	Large Fab - 12		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S266183



Part: D5763-11

Job No: 207395

Serial No/Batch: S266183

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Date: 3/24/20

25 2020

120 Packaging 3-1 - Stock - B4B 10 pcs

3/6/20 0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

130 QC 21 - SA

10 pcs

3/6/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

MAR 25 2020

Part Op 100 - 1- Cut as per D5763 DWG 2- Deburr

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Identify as per dwg & Stock Location: 10A-004

130 - QC21- Final Inspection - Work Order Release

Job BOM

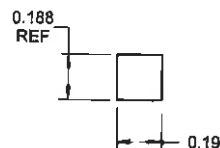
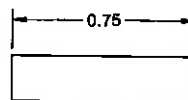
Part / Item	Component Name	Quantity	Operation	Container
M304B0.188X0.188	304 Bar, 0.188 X 0.188	.7410 ft (.0741 ea)	100-Large Fab - Welded Assy-1	5263536

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.188X0.188	1	0	0

Part Specifications

Specifications could not be found.



D5763-11 BLOCK
(DERIVED FROM AERO DESIGN P/N 69630-07)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR OR PLATE, 3/16 THICK
PER ASTM A276 OR ASTM A240 OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASME SA240
REF DART SPEC M304B OR M304S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

RELEASED

2020 FEB 19

UNDER REVIEW

URF 2020-524 20.02.20 (NO)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 207395 MJS
200225

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NO	DRAWING NO.	REV. A
MFG. APPR.	DD	D5763	SHEET 7 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	FWD BEAM	NTS
DATE	20.02.19	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045970



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 687 4248
Fax: 450 377 5696

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045970

PO Date: 2/27/20

Due Date: 3/13/20

Purchase Order

Revision:

Revision Date:

Issued By: Laviole, Chantal
Phone: 613-623-5200 Ext 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: quote no. SOU0243320

E-MAILED
MAR 02 2020

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M17-4-B1.250X2.000			17-4 SS Bar 1 250 x 2.00 MATERIAL 17-4 PH SS BAR AS PER AMS 5604/5643 GRAIN MUST BE ALONG LENGTH OF BAR MIN. YIELD TENSILE STRENGTH = 100 KSI MIN. ULTIMATE TENSILE STRENGTH = 150 KSI receive ft	Firmed -		3/13/20	12 ft	0 ft	12 ft	\$95.08333/ft	\$1,141.00
2		M304B0 375X03.000			M304 SS bar 375 x 3.00 MATERIAL AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A278 OR ASTM A240 NOTE AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/5/20	12 ft	0 ft	12 ft	\$11.335/ft	\$136.02
3		M304B0 188X0.188			304 Bar, 0.188 X 0.188	Firmed -		3/5/20	12 ft	0 ft	12 ft	\$1.29/ft	\$15.48

**ACIER GUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 MB: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 MB: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT

CO00194479

Billed to
DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Instruction F-M

Delivery Route 5

Customer N° CLI0001056
Date 2020/03/02
Delivery date 2020/03/13
Your order N° POHB045970
Processed by Josianne Bourdon
Salesman JOSIANNE BOURDON
Carrier GUELLETTE VALLEYFIELD
Credit Terme Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 PLATE SS 1 1/4 17-4 PH RIS PSS-114174 10061 1 X 2" X 12' R/L POHB045970 LINE 1 HEAT: 92100401 AC34489-JO-11/03	106.15	2.00	PI2_\$CLB		1X 159"						
2 FLAT SS304 3/8 X 3 (R) FSS-383 3578 1 X 12' R/L POHB045970 LINE 2 HEAT: 1017570	45.96	12.00	PI_\$CLB		1X12'						
3 SQUARE SS 3/16 SS304 CSS-316 8678 1 X 12' R/L POHB045970 LINE 3 HEAT: 5R820 AC34596-CF-05/03	1.44	12.00	PI_\$CLB		1X12"						
4 FLAT SS304 5/8 X 3 FSS-583 9221 1 X 12' R/L POHB045970 LINE 4 HEAT: 51035 AC34489-JO-11/03	76.56	12.00	PI_\$CLB		1X12"						
5 SHEET SS 16G SS304-2B (4 X 8) DART FESSD-16G483042B 12463 6 X 4' X 8' POHB045970 LINE 5	504.00	192.00	PI2_\$CLB		6X4'X8'						

RECEIVED

MAR 13 2020

DART AEROSPACE LTD.

LINE 3

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304B 0.188 X 0.188

PO / BATCH NO.: P0413045970
5263536

DATE: MAR 17 2020

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 12 FT
QUANTITY INSPECTED: 12 FT
QUANTITY REJECTED: —

THICKNESS ORDERED: .188 X .188
THICKNESS RECEIVED: .188 X .188
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <input checked="" type="checkbox"/>	
CORRECT FINISH	<input checked="" type="checkbox"/> N	
CORROSION	Y <input checked="" type="checkbox"/>	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> N	
CORRECT MATERIAL PER M-DRAWING	<input checked="" type="checkbox"/> N	<u>A5707 A276</u>
CORRECT THICKNESS	<input checked="" type="checkbox"/> N	
PHOTO REQUIRED	Y <input checked="" type="checkbox"/>	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> N	<u>R/T 5R820</u>
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <input checked="" type="checkbox"/>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <input checked="" type="checkbox"/>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>MAR 17 2020</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LINE 3

M 304 B 0.188 X 0.188

SPECIFICATION CONTROL DRAWING

△ PURCHASE MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
(NOTE: AISI 308 NOT ACCEPTABLE)

△ SPECIFICATION: ASTM A276 OR ASTM A240

PART NUMBER: M304B T TTT X WWW WWW
THICK WIDTH

WHERE "T TTT" = THICKNESS IN INCHES
AND "WWW WWW" = WIDTH IN INCHES

△ EG 0.5" X 3.0" BAR = M304B0.500X0.188
EG 0.5" X 12.0" PLATE = M304B0.500X12.000

DAS
82
9-80

RELEASED
81 2010-11-30

C	ADDED PLATE TO PURCHASE MATERIAL. ADDED PLATE RELATED SPECIFICATIONS AND EG CHANGED TITLE FROM "304/316 BAR" TO "304/316 BAR/PLATE"	MB	10.11.25
B	REFORMAT DRWG. ADO SPEC. (TN 06-1) REF PAR 08-020A	LP	09.07.15
A	NEW ISSUE	PH	05.06.10
REV.	DESCRIPTION	BY	DATE
DESIGN	EL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	h		
CHECKED	h		
MFG. APPR	h		
DE APPR	h		
DATE	10.11.25	REV C SHEET 1 OF 1 SCALE NTS	
304/316 BAR/PLATE		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT SHALL BE KEPT IN THE COMPANY'S FILES AND NOT BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN AUTHORIZATION OF DART AEROSPACE LTD.	

56933 34596

8678
CSS-316
(3)



INSPECTION CERTIFICATE

WALSIN LINHA CORP.

YENSHUI PLANT
台南市安平區永興路1281210號
NO 3-10, YENSHUI LIAO, QIAN SUPEI LI.
YENSHUI DIST TAINAN CITY 73743, TAIWAN, R.O.C.
TEL: 886-6-452-0911 FAX: 886-6-452-0954

222440

CUSTOMER: TA CHIN INTERNATIONAL, INC.
COMMODITY: Stainless Steel Cold Drawn Square Bar
CERTIFICATE NO: A1806150103

ORDER NO.: 107060006/L76023
SPECIFICATION: 304/L
DOC NO.:

LC NO: BUK
SUPPLY CONDITION: CD
DATE OF ISSUE: 2018/08/15

Heat 58820

Heat No.	Thick (Dia)	Per	Si	Chemical Composition(%)												Mechanical Property						BUNDLE NO
				C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N			TS	YS	EL	RA	HRB	HRC	
	(inch)		(LBS)	x100	x100	x100	x1000	x1000	x100	x100	x100	x100	x10000			N/mm2	N/mm2	%	%			
Spec	Min								800	1800						620	510	30	40			
	Max			3	100	200	45	30	1200	2600			1000			795				100	24	
SR820	5/16"	394	1294	2.4	34	158	30	27.6	809	1811	14	50	791			738	617	52	68	96		W18145026
Total:				1294																		

TOLERANCE: A1806 **TESTING TOLERANCE: 0-50**

Acc. to AMS 5639J/5647Z/CD-6-7639/ASTM A276-12/A479-17 and 2017 ASME B475 Cond.A.
Acc. to ASTM A102-17/A193-17/A320-17/A354-24-EN Entry only. Acc. to ASTM A362 15 A & B.
Acc. to AISI 304/304L Heat treatment temperature: 1020°C min.
This inspection certificate is issued according to EN 10204 3.1

Remark:
Cold rolled manufactured : Taiwan , Improved machining.
Solution annealed treatment : Acc. to ASTM A484.
Micro structure: good., Grain size: Acc. to ASTM E112.

SUPPLY CONDITION:
A: Annealed
B: Shot Blasted
C: As Casted
E: Rolled/Skin Pass
H: Precipitation Hardening
HR: Hot Rolled
I: Straightened
R: Cut Edge
L: Polished
2: Cold Rolled
P: Pickled
S: Shaved
V: SD
W: Cut
X: Temper
CD: Cold Draw
CG: Centerless Ground
PL: Turned or Peened

We have the following certifications
1. ISO9001 2015 Quality Management System
2. ISO/IEC 17025:2005 Laboratory Management System
3. PED & AD2000-Markblatt W0
4. DNV - LR - ABS Classification Society certification
5. ISO14001:2015 Environment Management System
6. OHSAS 18001:2007 & TOSHMS Certificate

TEST METHOD:
CHEMICAL-ASTM E1806, E1815, E1806, E1819

J C Tseng
Quality Assurance Responsible Personnel

1. We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with requirement of the above material specification.
2. We certify that the material is free from mercury and radiation contamination. Qualification No. of Taiwan Atomic Energy Committee: 136
3. The Above Testing Results Relate Only To The Items Tested.
4. No welding repaired

WALSIN LINHA CORP.
Item: SB4L012 Bundle: WL18145026 Heat#: SR820
TA CHIN INTERNATIONAL, INC.
PO#: C13C074 504:ALLES
THIS MTR contains 1 page (Page: 1)
*****WALSIN*****

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Follo/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					